

Work Order ID 75781

October 28, 2011 12:04:05 PM

75781

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Item ID: D2622-120C

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Step Extrusion

Stop ***NS2***

Start Date: 10/28/11 Start Qty: 120.00

120

Cust Item ID:

Required Date: 11/24/11 Req'd Qty: 120.00

120

Customer:

Reference:

Approvals: Process Plan: CD Date: 11/2/28

Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2622	Rev C1
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100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 15298 a) Extrude as per Dwg D2622 Rev. Cb)
Material: 6061-T6 (QQ-A-200/8)c) Minimum yield tensile strength = 35
ksid) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation =
8%f) Order at 120" longg) Bon L Canada Inc.

CD 11/10/28 120

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

Pullup 2 11/8

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

Check Pull test per Dwg D2622 for compliance page attached Check hardness
with Webster tester

Su/11/23

counts
11/8

CD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75781

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Item ID: D2622-120C Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Extrusion
 Start Date: 10/28/11 Start Qty: 120.00 ***120*** Cust Item ID:
 Required Date: 11/24/11 Req'd Qty: 120.00 ***120*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <i>UA</i> Memo <i>* Pull B pes + give to QC for spot testy P whl</i>	0.00 0.00	<i>11.11.30</i>			<i>118</i>	<i>0</i>		
140 *140* QC Quality Control	QC21 - Final Inspection - Work Order Release Memo	0.00 0.00						<i>11/12/5</i>	<i>MF</i>

MF
11-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75781

Parent Item: D2622-120C

Parent Item Name: Step Extrusion

Start Date: 10/28/11

Required Date: 11/24/11

Start Qty: 120.00

Required Qty: 120.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120CP Extrusion		Purchased	No			110	Each	0.0000	1	120		10/28/11	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

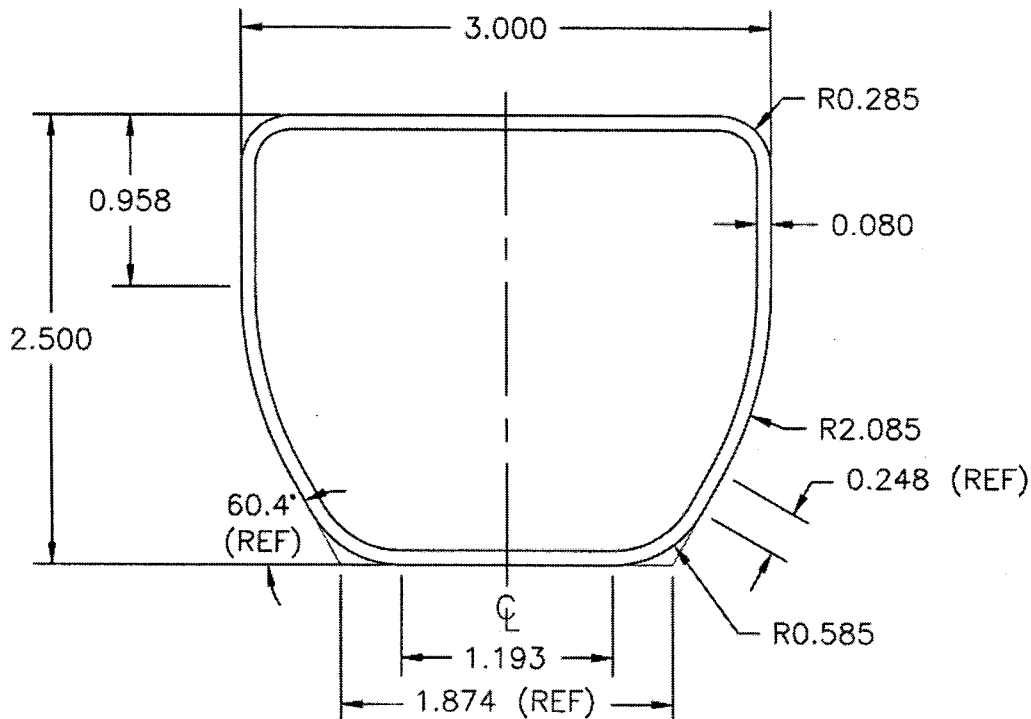
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	KE	DRAWN BY	4P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2622	REV. C. SHEET 1 OF 1
DATE	02.09.11			TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29			NEW ISSUE	
B	97.12.12			CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11			0.080 WAS 0.085; ADD PART & DIE No.	
CI	#	CP	02.10.04	ADD 'REV. A' TO DIE NUMBER.	

RELEASED
02.09.11 #



D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

CL 11110127
W10.75005

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15298

Purchase Order Date 10/28/11

PO Print Date 10/28/11

Page Number 1 of 1

Order From :

VC-BON001

SIGNATURE ALUMINUM
1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8
CA

Contact Name

Vendor Phone

800 563 1079

Vendor Fax

800 565 8339

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

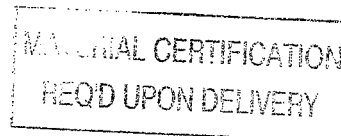
CL 11/10/28

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2622-120CP	Extrusion	11/25/11 Yes	120.00 Each	Yours ppd	\$28.7660	\$3,451.92

Special Inst: EXTRUDE AS PER DWG D2622 REV. C
B75781
MATERIAL: 6061-T6 AS PER QQ-A-200/8
MINIMUM YIELD TENSILE STRENGTH
= 35 KSI
MINIMUM ULTIMATE TENSILE
STRENGTH = 38 KSI
MINIMUM ELONGATION = 8%
120" LONG
SIGNATURE ALUMINUM DIE # 897123

PO Total:

\$3,451.92



W *CL*

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 10/28/11

ACCT# 46024

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

SHIPPING MANIFEST

MANIFEST DATE / DATE DU BODEREAU
11-20-11

MANIFEST NUMBER / N° DE BODEREAU
003526

SALES ORDER NUMBER / N° DE COM
103403

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCE

REFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

LOCATION	TRAILER NUMBER / REMORQUE Nombre	SALESMAN / VENDEUR	CREDIT REP / REP DU CRÉDIT	SALES REP / REP. DES VENTES
PIC	5300	042		G.ATTENBOROU
JOB / FICHIER		FIELD SALES REP / REP REGIONAL DES VENTES		CUST SERVICE REP / REP. SERVICE CLIENTELE
		G.ATTENBOROU		DLB
CARRIER / TRANSPORTEUR				
JODEE				

CUSTOMER ID / ID DU
CLIENT

46024

ORDER DATE / DE LA
COM

10/28/11

CUSTOMER PO NUMBER / CLIENT PO Nombre

15298

BILL OF LADING NUMBER / NO. DE CONNAISSEMENT

003526

ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	1,094	LB		DAA-897123-2	6061 T6		3	1,157	1,105	LB	
	496	KG		D2622	120.0000 IN			525	501	KG	
	120	PC			Cut(+): 0.1180 Cut(-): 0.0000 Min: 0 % Max: 0 %				118	PC	
						807843 / 124942	1	476	459		49 PC
						807843 / 124943	1	476	459		49 PC
						807843 / 124944	1	205	187		20 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

Page 1

DATE OF DELIVERY

DRIVER

3	1,157	1,105	LB
	525	501	KG
		118	PC
TOTALS			

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

Cert Date	Cert No.	Sales Order	Page
11/15/2011	5273309	103403	1
Cust PO	B/L No	Lot	Date
15298	003526	807843	11/20/11

Sold To		Ship To	
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA		46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	
Item No	Part No	Item Description	Cust Part
001	DAA-897123-2	10 Mill 6061 T6	D2622
Gross Weight	1,157 LBS		
Net Qty	1,105 LBS		
Specification	AMS-QQ-A-200/8 & ASTM B221-08		
		Die Desc	

Mechanical Tests:

Tensile	Yield			
MPA / KSI	MPA / KSI	% Elongation	Conductivity	HREW
302.1 / 43.8	273.8 / 39.7	9.5	0.0	92

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI	V
0.69	0.22	0.27	0.05	0.95	0.07	0.14	0.02	0.01

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta, Director of Quality Signature Aluminum Canada Inc